



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

VERIFIED
2023/4 AUTH
9 DATE 10.01.22
B-RU

D5853-041
Job Sheet 207011

PRELIMINARY ISSUE



OK to release @ Rev A
for ECN 20-521

Part No: D5853-041

Job Qty: 4 pcs

Part Name: Basket Rim Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/14/20

Job Tracking No:

Due Date: 3/13/20

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG D5853 Rev A IPP Rev. A 2020.01.30 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	4 pcs	3/13/20		0.00	0.80	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
150	QC 9	4 pcs	3/13/20		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
160	QC 5	4 pcs	3/13/20		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		

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Container No: S256663



Part: D5853-041

Job No: 207011

Serial No/Batch: S256663

Revision: A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/18/20

Plax 2/14/20 2:19 PM dart.lacelle.linda

				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 51	
				QC 5 - 81	
170 Packaging 3-1 - Stock - B4B 4 pcs	3/13/20	0.00 0.00		Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
180 QC 21 - SA	4 pcs	3/13/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 82	

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MAR 02 2020
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MA

Part Op 180 - 1- Cut as per dwg D5853-1 2-Drill holes with EIT10653 as per dwg D5853-1 ***DRILL ONE SIDE*** 3-Deburr, 4-
 Descriptions: Weld as per drawing, 5-Back drill support as per drawing note 8.
 150 - (QC6- Inspect visual per Q51004- Fusion Welds)
 160 - QC5- Inspect part completeness to step on W/O
 170 - Identify as per dwg & Stock Location: _____ As per drawing, see note 8.
 180 - QC21- Final Inspection - Work Order Release

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MAR 10 2 2020

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5853-7	Support	4 pcs (1 ea)	100-Large Fab - Basket - 1	
M4130NTS0.750W.035	4130 Square Tube 0.750 X 0.035W	7,6000 ft (1.9 ea)	100-Large Fab - Basket - 1	5250 794

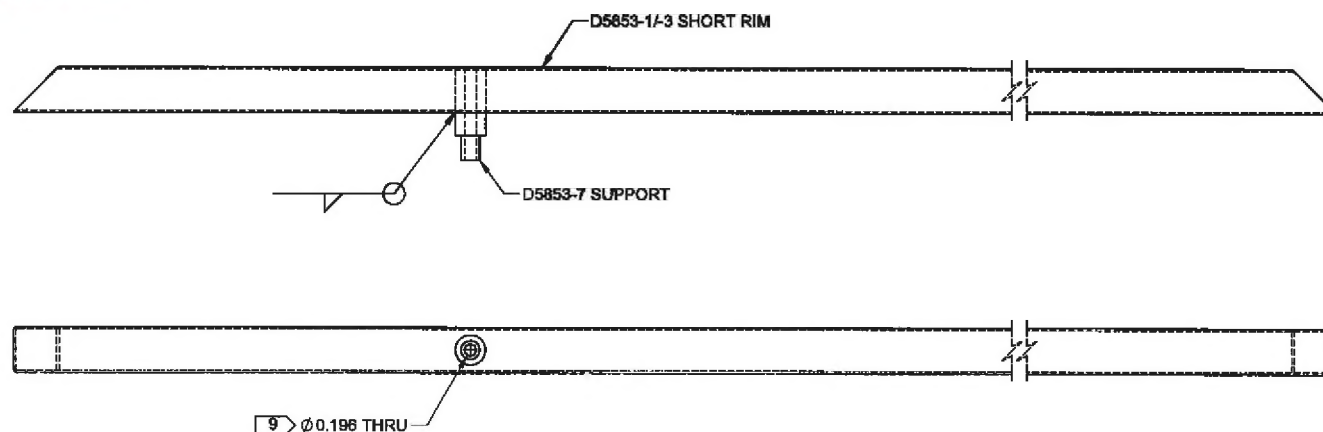
DAS
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9-88

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D5853-7	4	0	0
	M4130NTS0.750W.035	8	608	0
Part Specifications				
Specifications could not be found.				

Plex 2/14/20 2:19 PM dart.lacelle.linda

QTY -041	QTY -043	P/N	DESCRIPTION
X		D5853-041	BASKET RIM WELDMENT
	X	D5853-043	BASKET RIM WELDMENT
1		D5853-1	SHORT RIM
	1	D5853-3	SHORT RIM
1	1	D5853-7	SUPPORT

PRELIMINARY ISSUE



D5853-041 BASKET RIM WELDMENT
D5853-043 BASKET RIM WELDMENT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND SERIAL NUMBER PER DART QSI 044 8.6
- 7) WEIGHT: -041: 0.65 lbs
-043: 0.73 lbs
- 8) WELD PER DART QSI 004
- 9) DRILL THRU SUPPORT AND TUBE AFTER WELDING.

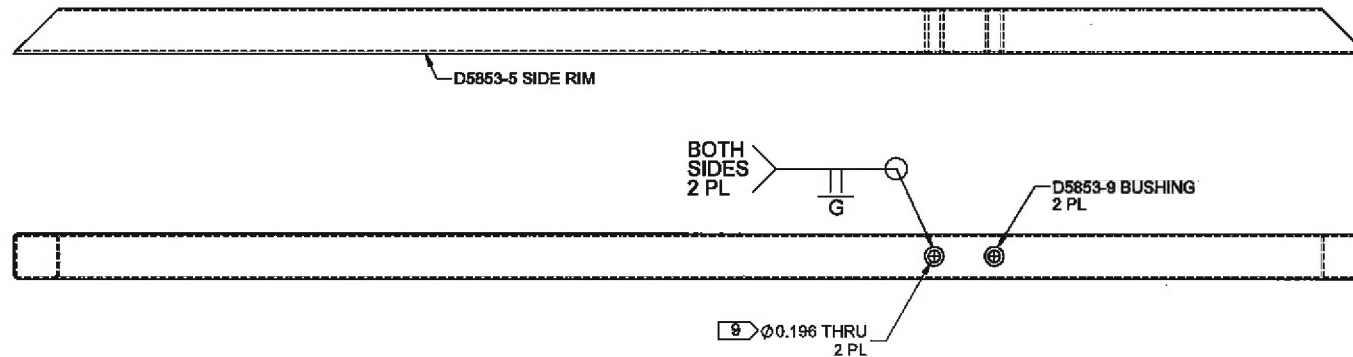
PRELIMINARY ISSUE

REV.	NEW ISSUE	DESCRIPTION	ZF	20.01.24
DESIGN	ZF		BY	DATE
DRAWN	ZF			
CHECKED	KPT	DRAWING NO.		REV. A2
MFG. APPR.	DD	D5853		SHEET 1 OF 8
APPROVED		TITLE		SCALE
DE APPR.		BASKET RIM		NTS
DATE	20.01.24	COPYRIGHT © 2020 BY DART AEROSPACE LTD		

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QTY -045	P/N	DESCRIPTION
X	D5853-045	LID RIM WELDMENT
1	D5853-5	SIDE RIM
2	D5853-9	BUSHING

PRELIMINARY ISSUE



D5853-045 LID RIM WELDMENT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND SERIAL NUMBER PER DART QSI 044 6.6
- 7) WEIGHT: 0.61 lbs
- 8) WELD PER DART QSI 004
- 9) DRILL THRU BUSHINGS AFTER WELDING.

PRELIMINARY ISSUE

DESIGN	ZF	DART AEROSPACE LTD	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	DRAWING NO.	REV. A2
MFG. APPR.	DD	D5853	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET RIM	NTS
DATE	20.01.24	<small>COPYRIGHT © 2020 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE BASIS THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COPIED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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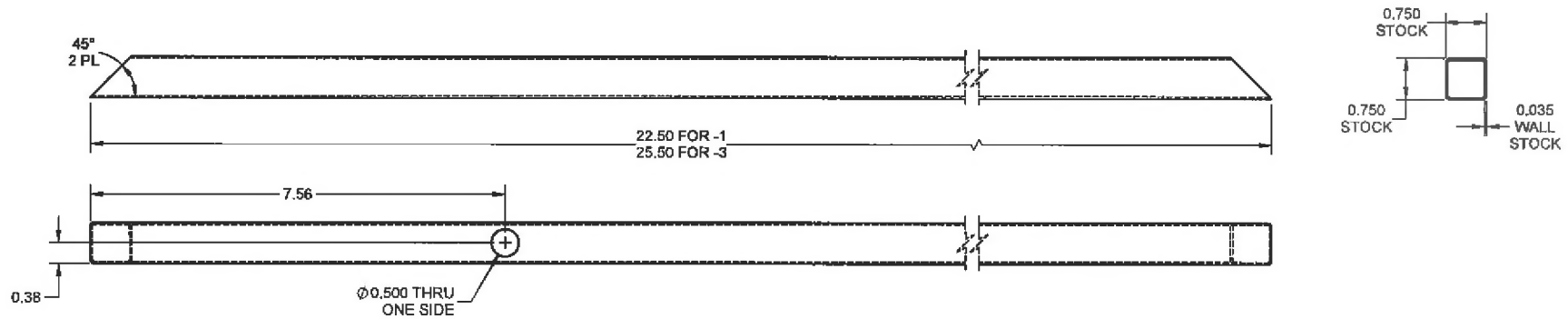
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A

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D5853-1 SHORT RIM
D5853-3 SHORT RIM

PRELIMINARY ISSUE

NOTES:

- 1) MATERIAL: AISI 4130N STEEL SQUARE TUBING, 3/4 X 0.035 WALL
PER MIL-T-8738 OR AMS 6371/6370/6361/6362/6373/6374
REF DART SPEC M4130N-TS
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: -1: 0.59 lbs
-3: 0.68 lbs

PRELIMINARY ISSUE

DESIGN	ZF	DART AEROSPACE LTD	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	DRAWING NO.	REV. A2
MFG. APPR.	DD	D5853	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET RIM	NTS
DATE	20.01.24	<small>COPYRIGHT © 2020 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED IN ANY MANNER OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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8 7 6 5 4 3 2 1

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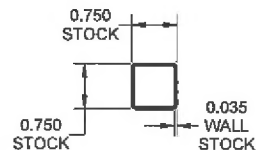
22.50

15.31

1.000

Ø0.313 THRU
BOTH SIDES
2 PL

0.38



D5853-5 SIDE RIM

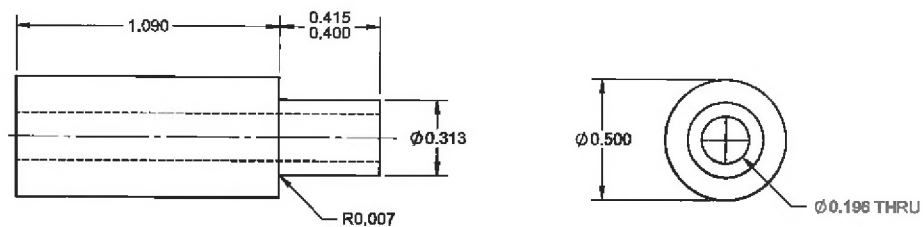
NOTES:

- 1) MATERIAL: AISI 4130N STEEL SQUARE TUBING, 3/4 X 0.035 WALL
PER MIL-T-8736 OR AMS 6371/6370/6361/6362/6373/6374
REF DART SPEC M4130N-TS
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.59 lbs

PRELIMINARY ISSUE

DESIGN	ZF	DART AEROSPACE LTD	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	DRAWING NO.	REV. A2
MFG. APPR.	DD	D5853	SHEET 4 OF 8
APPROVED		TITLE	SCALE
DE APPR.		BASKET RIM	NTS
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D5853-7 SUPPORT
(DERIVED FROM AERO DESIGN P/N 70422-05)

NOTES:

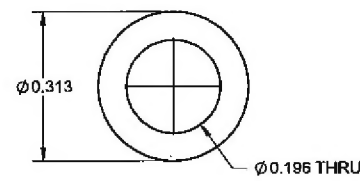
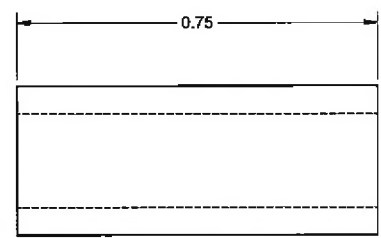
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR
PER ASTM A276 OR ASTM A479
REF DART SPEC M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.06 lbs

PRELIMINARY ISSUE

PRELIMINARY ISSUE

DESIGN	ZF	DART AEROSPACE LTD	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	DRAWING NO.	REV. A2
MFG. APPR.	DD	D5853	SHEET 5 OF 8
APPROVED		TITLE	SCALE
DE APPR.		BASKET RIM	NTS
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• A2171 Bear paw clamp.
• Tals bending wearplate
• Beed roller wearplate
• A357c



D5853-9 BUSHING
(DERIVED FROM AERO DESIGN P/N 70422-04)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBE, 5/16 OD X 0.058 WALL
PER ASTM A213 OR ASME SA213 OR ASTM A289
REF DART SPEC M304TR
OR
AISI 304/316 STAINLESS STEEL ROUND BAR
PER ASTM A276 OR ASTM A479
REF DART SPEC M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.01 lbs

PRELIMINARY ISSUE

PRELIMINARY ISSUE

DESIGN	ZF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ZF		
CHECKED	KPT	DRAWING NO.	REV. A2
MFG. APPR.	DD	D5853	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET RIM	NTS
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045594



Supplier: FAC001-VU
Factory Steel
14020 Oakland Ave.
Detroit, MI 48203 USA
Phone: 313 883 6300
Fax: 313 883 4883

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045594

PO Date: 1/16/20

Due Date: 2/4/20

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

JAN 16 2020

Items													
Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1		M4130NTS1.000W.065			4130 Square Tube 0.750 X 0.035W : MATERIAL: AISI 4130N STEEL SQUARE TUBING PER ONE OF THE FOLLOWING SPEC'S: MIL-T-6736, AMS 6371, 6390, 6361, 6362, 6373 OR 6374	Firmed		2/4/20	800 ft	0 ft	800 ft	\$7.25/ft	\$4,350.00
2		M4130NTS1.000W.065			4130 Square Tube 1.000" X 1.000" X 0.065"W : MATERIAL: AISI 4130N STEEL SQUARE TUBING PER ONE OF THE FOLLOWING SPEC'S: MIL-T-6736, AMS 6371, 6390, 6361, 6362, 6373 OR 6374	Firmed		2/4/20	160 ft	0 ft	160 ft	\$11.70/ft	\$1,872.00
Grand Total: \$6,222.00													



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 832-5200

PURCHASE ORDER**POHB045594****Order Notes****Procurement Quality Clauses**

- A005 right to entry
- A012 chemical and physical test report
- A016 personnel qualification
- A017 raw material identification (as applicable). No Raw Metals from China or Soviet Bloc Countries. (DFARS)
- A026 certification of material conformance
- A041 quality management system
- A042 dart notification by supplier
- A043 retention of quality documents

- A048 counterfeit parts avoidance, detection, mitigation and disposition program.

- A049 supplier awareness.

Terms & Condition of Purchasing (Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 1/16/20 11:38 AM Dart.Lavoie.Chantal

PACKING LIST

No. 67371

PG 1 OF 1

PL

FACTORY STEEL & METAL SUPPLY 14020 OAKLAND AVENUE DETROIT, MI 48203		CUSTOMER # POHB045594		BUYER CHANTEL LAVOIE		SHIP DATE 01/21/2020	
(313)883-6300 PHONE (313)883-4883 FAX		CUSTOMER JOB		Tel (613) 632-3336 Fax (613) 632-4443		SHIP VIA ****TRUCK****	
SOLD TO DART AEROSPACE 1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7		SALES ORDER 60306		ORDER DATE 01/16/2020		SALES REP MICK HALON	
		SHIP TO DART AEROSPACE 1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7		SHIP INST CALL WHEN READY		RESALE # 59-2958719	
				PRO#		CARRIER TRUCK	
				TERMS NET 30 DAYS		BLIND Y/N N	
						FOB DETROIT	

LINE	QUANTITY	DESCRIPTION	WIDTH	LENGTH	WEIGHT
1	609.917 FT	4130N CD SNLSS SQ TUBE 3/4" X .035W Tag Mill Ref # Heat 153513 023679 616506	Pcs Length 26 20'/24' RL	20'/24' RL Feet 609.917	207.554 Weight 207.554
2	171.333 FT	4130N CD SNLSS SQ TUBE 1" X .065W Tag Mill Ref # Heat 153514 072143 072067859	Pcs Length 7 22'/23' RL	22'/23' RL Feet 171.333	141.606 Weight 141.606
3	1 PCS	PACKING CHARGES MTRS (CIRCLE) FAX SHIPMENT INVOICE ALL DATE: _____ INITIAL: _____			

TOTAL WT 349 LBS											
RECEIVED BY - SIGNATURE				RECEIVED BY - PRINTED NAME				DATE RECEIVED			

50

LIVE 1
M4130NTS 01750W.035

616506

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAYKESBURY, ONTARIO, CANADA	
CHECKED HT	APPROVED HT	DRAWING NO. M4130N-TS	REV. A SHEET 1 OF 1
DATE 05.02.09		TITLE 4130N SQUARE TUBING	SCALE NTS
A	05.02.09	NEW ISSUE	

PURCHASE MATERIAL:

AISI 4130N STEEL SQUARE TUBING PER ONE OF
THE FOLLOWING SPEC'S: MIL-T-6736, AMS 6371,
6360, 6361, 6362, 6373 OR 6374

DAS
9-89

PART NUMBER:

M4130N-TS | A.AAA | W | .TTT |

WHERE A.AAA = WIDTH IN INCHES
TTT = WALL THICKNESS IN INCHES

EXAMPLE: 0.50" X 0.035" WALL = M4130N-TS0.500W.035

05.03.05 PH

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PLYMOUTH TUBE CO.

1200 E. 12th St., Detroit, MI 48203
Phone: (313) 472-1611 Fax: (313) 472-1433
TOLL FREE: 1-800-368-5725



PRODUCT CERTIFICATION

SALES ORDER - LINE / RLS

173629 - 3 / 0

SHIP TO

Factory Steel & Metal Supply C
14020 Oakland Avenue
Detroit, MI 48203
USA

WORK ORDER 023879

PCS/HEAT 0

HEAT NUMBER 616506

MELT SOURCE Benckel Steel & Tube Germany

CUSTOMER P.O.	CUSTOMER PART	QUANTITY	LADING NO	CERT ID / REV	CERT DATE								
3887	SQ-N34035												
PART DESCRIPTION SHSQ0750035J300 ***** Square OD ***** Side1: 0.7500 Max:0.7600 Min:0.7400 Side2: 0.7500 Max:0.7600 Min:0.7400 Wall: 0.0350 Max:0.0380 Min:0.0320 Length: 12.00/25.20 Spec: Seamless Aircraft Grade: 4130 Anneal: Cond N													
CERTIFICATION REQUIREMENTS FAR BAA (FAR 52.225-1 Buy America Act Supplies). DFARS 252.225-7001 Buy America Act & Bal. of Payments Program FAR TA (FAR 52.225-5 Trade Agreements)(Paragraph 1,3,4,5) This material was Eddy Current tested and conforms to the requirements of ASTM A-450. The Grain size is determined and reported by the raw material supplier in accordance to ASTM E-112. This raw material was magnetic particle inspected by the raw material supplier in accordance to AMS 2840J and/or ASTM E-1444, and rated as Frequency, and Severity to AMS 2301, latest revision. Yield is determined by using the 0.2% offset method. Additional Specifications - AMS-T 6736B, 6380P & 6371L. Material produced in accordance to ASTM A-519-17 and MIL-T-6736B. This material meets Plymouth ProMoly specifications. Jominy results: J(5/16")=45 J(8/16")=35													
Chemical Analysis													
C	Mn	P	S	Si	Al	Cr	Mo	Ni	Pb	Cu	V	Ti	Sn
.310	.55	.011	.002	.230	.036	.87	.18	.12	.001	.16	.002	.002	.010
Physical Properties													
Freq.	Severity	Grain Size											
.020	.015	9											
Mechanical Properties													
TEST	UNITS	#TESTS	HIGH	LOW	AVERAGE	STD-DEV							
Tensile	Psi	6	126660	125480	126065	482							
Yield	Psi	6	120930	118880	120387	374							
Elongation	%	6	21	20	20	1							
Rockwell C	Rc	6	25	25	25	0							
TEST	RESULT												
Decarb/OD	Pass												
Total ID/OD discard	Pass												

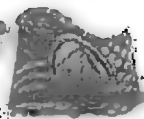
I certify that the results are a true and correct copy of the records prepared and maintained by Plymouth Tube Company. Streater in compliance with the requirements of the cited specification. Chemistry is as reported by the Steel supplier. This test report cannot be reproduced or distributed except in full without the written permission of Plymouth Tube.

James H. Heston
Quality Assurance



PLYMOUTH TUBE CO.

1209 E. W. 12th Street, St. Louis, MO 63103
Phone: (314) 431-1818 Fax: (314) 431-1819



PRODUCT CERTIFICATION

SALES ORDER - LINE / RLS

175629 - 1 / 0

SHIP TO

Factory Steel & Metal Supply C
14020 Oakland Avenue
Detroit, MI 48203
USA

WORK ORDER 023679

PCS/HEAT 0

HEAT NUMBER 616506

MELT SOURCE Benkel Steel & Tube-Germany

CUSTOMER P.O.	CUSTOMER PART	QUANTITY	LOADING NO	CERT ID / REV	CERT DATE
3887	SQ-N34035			/	
PART DESCRIPTION		SHSQ0756035J300			
Additional Specification(s)					
<u>TEST</u>	<u>UNITS</u>	<u>#TESTS</u>	<u>HIGH</u>	<u>LOW</u>	<u>AVERAGE</u>
Brinell	Brinell	6	253	253	253
<p>This test report data is for the heat Chemistry Stated above.</p> <p>The material in this test report is:</p> <ol style="list-style-type: none"> 1) Drawn in the USA 2) Free from Polybrominated Biphenyls (PBB), Polybrominated Diphenyl Ethers (PBDE), and Mercury contamination. 3) N. FTA compliant. <p>End of Certification</p>					

I certify that the results are a true and correct copy of the records prepared and maintained by Plymouth Tube Company, Streater in compliance with the requirements of the cited specification. Chemistry is as reported by the Steel supplier. This test report cannot be reproduced or distributed except in full without the written permission of Plymouth Tube.

Janice Blumsohn
Quality Assurance

Live

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: M4130NTS0.750W.035 PO / BATCH NO.: POMB045594
DATE: JAN 27 2020 5250794

MATERIAL CERT REC'D: YES THICKNESS ORDERED: .750W.035
QUANTITY RECEIVED: 609 PT THICKNESS RECEIVED: .750W.035
QUANTITY INSPECTED: 609 PT SHEET SIZE ORDERED: —
QUANTITY REJECTED: 0 SHEET SIZE RECEIVED: —

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y (N)	
CORRECT FINISH	(Y) N	
CORROSION	Y (N)	
CORRECT GRAIN DIRECTION	(Y) N	
CORRECT MATERIAL PER M-DRAWING	(Y) N	MIL-T-6736
CORRECT THICKNESS	(Y) N	
PHOTO REQUIRED	Y (N)	
CORRECT REF # TO LINK CERT	(Y) N	666506
CORRECT MATERIAL IDENTIFICATION	(Y) N	
CORRECT M# ON THE MATERIAL	(Y) N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y (N)	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y (N)	

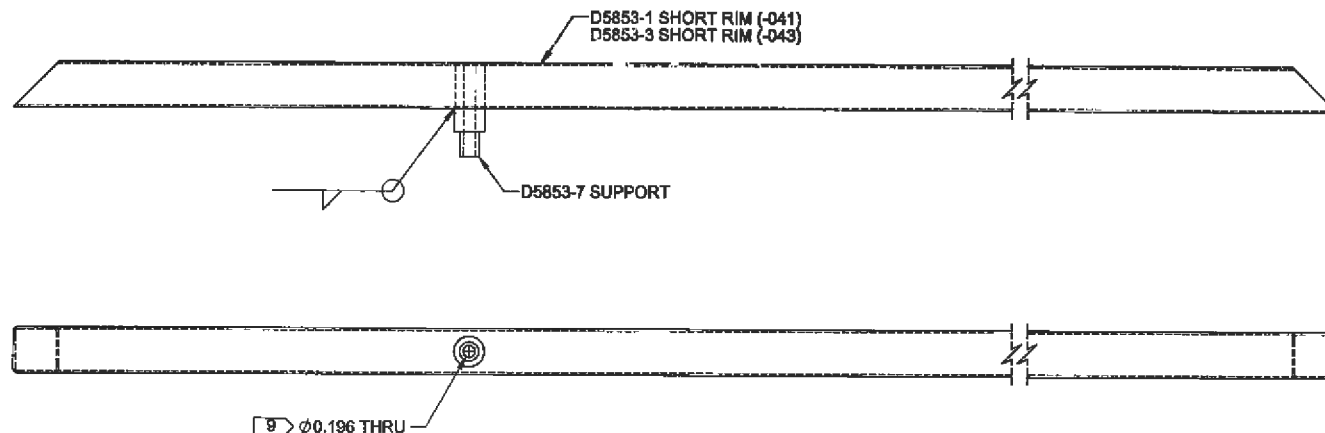
CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNATURE (if required)	
INSPECTED BY: _____	DAS	SIGNED OFF BY: _____	
DATE: <u>JAN 27 2020</u>	32 0.89	DATE: _____	

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

QTY -041	QTY -043	P/N	DESCRIPTION
		D5853-041	SHORT RIM WELDMENT
	X	D5853-043	BASKET RIM WELDMENT
1		D5853-1	SHORT RIM
1		D5853-3	SHORT RIM
1		D5853-7	SUP. JOINT



D5853-041 BASKET RIM WELDMENT
D5853-043 BASKET RIM WELDMENT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
- 7) WEIGHT: -041: 0.65 lbs
-043: 0.73 lbs
- 8) WELD PER DART QSI 004
- 9) DRILL THRU SUPPORT AND TUBE AFTER WELDING.

RELEASED

2020 FEB 18 *ND*
ECN 2020-521

UNDER REVIEW
URF 2020-522 20.02.14 (NO)

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	ZF	20.01.24
DESIGN	ZF		
DRAWN	ZF		
CHECKED	KPT		
MFG. APPR.	DD		
APPROVED	NO		
DE APPR.	CP		
DATE	20.01.24		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D5853

TITLE

BASKET RIM

REV. A

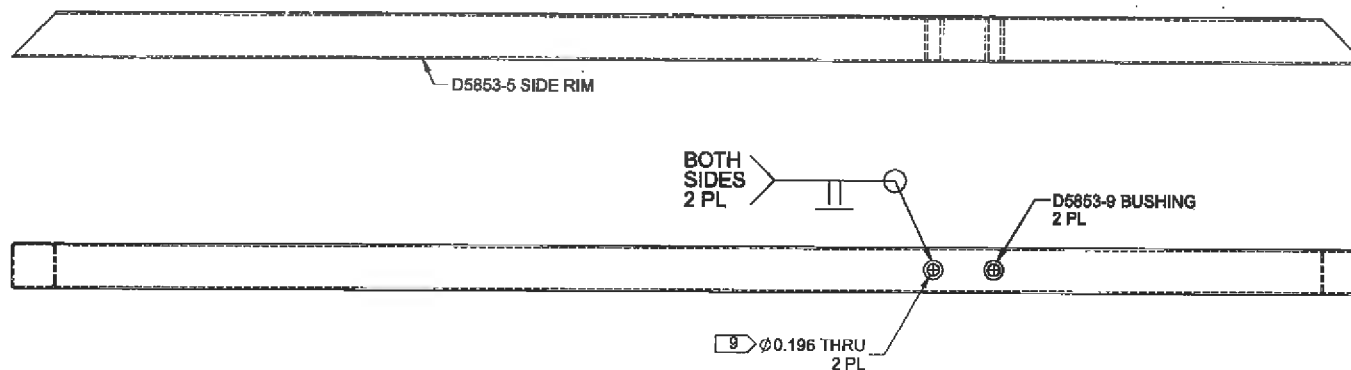
SHEET 1 OF 8

SCALE

NTS

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THE WRITTEN PERMISSION OF DART AEROSPACE LTD.

QTY -045	P/N	DESCRIPTION
X	D5853-045	LID RIM WELDMENT
1	D5853-5	SIDE RIM
2	D5853-9	BUSHING



D5853-045 LID RIM WELDMENT

UNDER REVIEW
URF 2020-522 20.02.14 (NO)

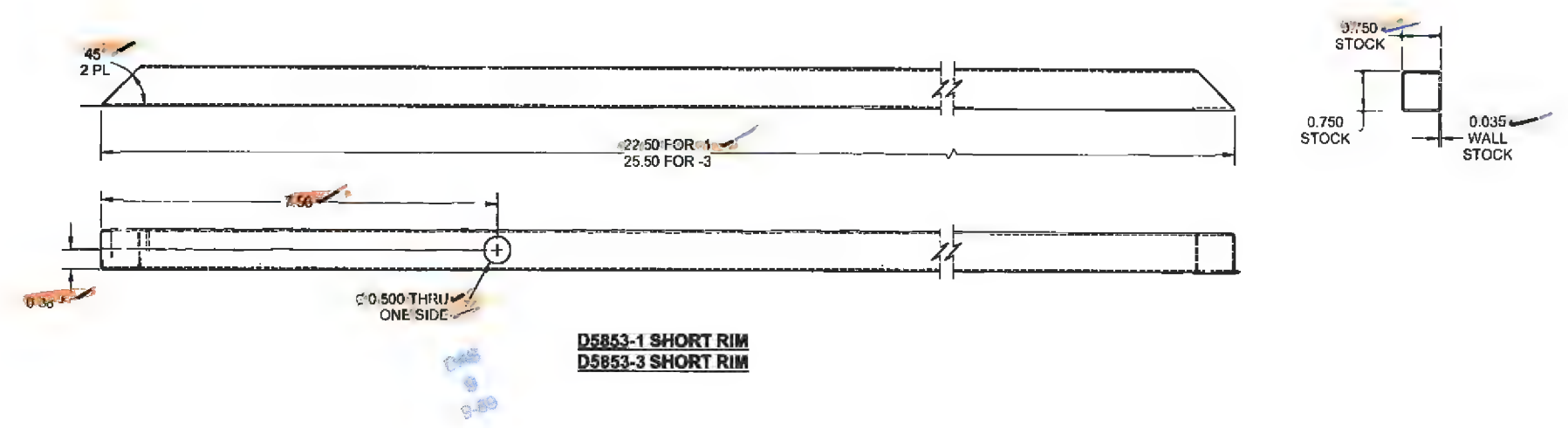
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
 - 7) WEIGHT: 0.61 lbs.
 - 8) WELD PER DART QSI 004. GRIND WELDS FLUSH IF REQUIRED.
 - 9) DRILL THRU BUSHINGS AFTER WELDING.

RELEASED
2020 FEB 18 *NCo*

APPROVED

DESIGN	ZF	DART AEROSPACE LTD	REV. A
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	DRAWING NO.	
MFG. APPR.	DD	D5853	SHEET 2 OF 6
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	BASKET RIM	NTS
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8 7 6 5 4 3 2 1



UNDER REVIEW

URF 2020-522 20.02.14 (NO)

- NOTES:
- 1) MATERIAL: AISI 4130N STEEL SQUARE TUBING, 3/4 X 0.035 WALL PER MIL-T-8736 OR AMS 6371/6360/6361/6362/6373/6374 REF DART SPEC M4130N-TS
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: -1: 0.59 lbs
-3: 0.68 lbs

RELEASED
2020 FEB 18

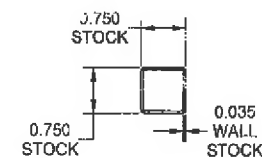
APPROVED

DESIGN	ZF	DART AEROSPACE LTD	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	DRAWING NO.	REV. A
MFG. APPR.	DD	D5853	SHEET 3 OF 8
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8 7 6 5 4 3 2 1

45°
2 PL

22.50



1.000

6.19

0.38

Ø0.313 THRU
BOTH SIDES
2 PL

D5853-5 SIDE RIM

UNDER REVIEW

URF 2020-522 20.02.14 (NO)

NOTES:

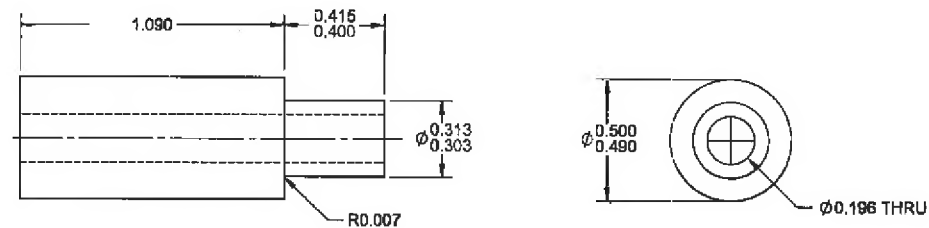
- 1) MATERIAL: AISI 4130N STEEL SQUARE TUBING, 3/4 X 0.035 WALL
PER MIL-T-8736 OR AMS 8371/8360/8361/8362/8373/8374
REF DART SPEC M4130N-TS
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.59 lbs

RELEASED

2020 FEB 18 NO

APPROVED

DESIGN	ZF	DART AEROSPACE LTD	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	DRAWING NO.	REV. A
MFG. APPR.	DD	D5853	SHEET 4 OF 6
APPROVED	NO	TITLE	SCALE
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D5853-7 SUPPORT
(DERIVED FROM AERO DESIGN P/N 70422-05)

UNDER REVIEW

URF 2020-522 20.02.14 (NO)

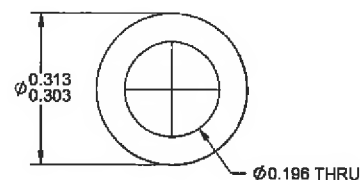
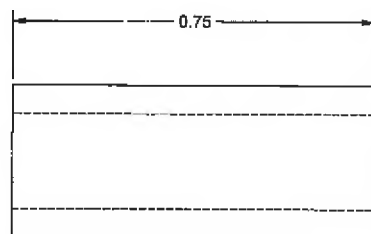
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR
PER ASTM A276 OR ASTM A479
REF DART SPEC M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.06 lbs

RELEASED
2020 FEB 18 WQ

APPROVED

DESIGN	ZF	DART AEROSPACE LTD	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	DRAWING NO.	REV. A
MFG. APPR.	DD	D5853	SHEET 5 OF 6
APPROVED	NO	TITLE	SCALE
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D5853-9 BUSHING
(DERIVED FROM AERO DESIGN P/N 70422-04)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR
PER ASTM A276 OR ASTM A479
REF DART SPEC M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.01 lbs

UNDER REVIEW

URF 2020-522 20.02.14 (NO)

RELEASED

2020 FEB 18 yfo

APPROVED

DESIGN	ZF	DART AEROSPACE LTD	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	DRAWING NO.	REV. A
MFG. APPR.	DD	D5853	SHEET 6 OF 6
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	BASKET RIM	NTS
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ENGINEERING CHANGE NOTICE

DART AEROSPACE LTD

Date:	2020.02.14	Job No.:	Aero2019	ADR Yes/No:	N	ADR Date:		ECN #:	2020 521
Product No.:	D350-1080 baskets			Created By:	NO	Approved By:	<i>AP</i>		
Product Name:	Quick Release Cargo Baskets			Checked By:					

Reason for Change:
D350-1080 Baskets Limited Release #1

Documents Released:
D5785 at Rev A, D5795 at Rev A, D5794 at Rev A, D5770 at Rev A, D5815 at Rev A, M304 TS at Rev E, M3003H22TP at Rev A, D5806 at Rev A, M302SW at Rev B
D5759 at Rev A, D5805 at Rev A, D5803 at Rev A, D5853 at Rev A, D5765 at Rev A, D5760 at Rev A, D5761 at Rev A, D5802 at Rev A, D5808 at Rev A, D5810 at Rev A.

IF APPLICABLE: NCR: _____ PAR: _____ CAR: _____ CIR: _____ URF: 2020-522

PAPERWORK UPDATE



PARTS MUST COMPLY



PREVIOUS PARTS SATISFACTORY



#	Quality Assurance / Customer Support Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Airbus	N			
3	Notify Leonardo	N			
4	Manufacturing Licensing Agreement Update	N			

#	Engineering Actions	Reqd	Resp	Notes	Complete
5	Required Documents/Drawings/Item ID's Under Review (URF)	Y	NO	ALL RELEASED PARTS PLACED UNDER REVIEW	<i>met 20.02.18</i>
6	Update Master Document List (MDL)	N		NO MDL/STC FOR THESE PARTS AT THIS TIME	
7	Update Document Record (DR)	N			
8	Update Product Compatibility Matrix	N			
9	Notify TCI / FAA / EASA (eg. ICA, 8110-3)	N			
10					

#	Document Control Actions	Reqd	Resp	Notes	Complete
11	Move / Update Electronic Files / Design Journal	Y	MG		<i>met 20.02.18</i>
12	Update Product Specification Files (Bluefiles)	N			
13	Update Approvals/Preliminary Dwg PDF Files	Y	MG		<i>met 20.02.18</i>
14	Update Product Development Summary (STC applications)	N			
15	Update CSI 021 (D/F-A- STC) and/or STC Approval List	N			
16	Create/ Update Parts / STC Database	Y	MG		<i>met 20.02.18</i>
17	Update / Verify Authorized Release Certificate Database	N			
18	Create / Update Change Record Form / Item Card Database	N		NO TOP LEVELS AT THIS RELEASE	
19	Create / Update Packaging Process Plan (PPP)	N			
20	Red Decals required on Packaging Process Plan (PPP)?	N			
21	Update Controlled Supplier Documents (Qpulse) Database	Y	MG	No dwgs at suppliers	<i>met 20.02.18</i>
22	Update Grey Project Binder / Electronic Project Folder	N			
23	Update D-Part / M-Drawing / DSI / DEO Master Binders	Y	MG		<i>met 20.02.18</i>
24	Update "Royalty Paid to" attributes (Parts sold under Dart USA STC's)	N			
25					

Description / Action:

Releasing first batch of D350-1080 basket drawing updates for production under Limited Release per QSI 040.

Place all parts under review, Engineering to sign off work orders for on risk production

No STC for these parts at this time

No nine digit BOMS/ROUTES/CHG#S for this release

Previous Parts Satisfactory for M Drawing updates. M Drawings not under Review

ECN Verified & Complete: _____

Date: _____